

1 (currently amended). An injection molded article having an electroluminescent panel as a first surface of the article, said article characterized in that the ~~panel includes a removable release layer overlying the panel to support the panel during~~ lamp is an integral part of the article as a result of injection molding.

2 (previously presented). The article as set forth in claim 1 wherein said panel emits light outwardly from the first surface.

3 (original). The article as set forth in claim 1 wherein said panel emits light into said article.

4 (previously presented). The article as set forth in claim 1 wherein said first surface is three dimensional.

5, 6, 7 (canceled)

8 (previously presented). The article as set forth in claim 1 and further including a graphics layer.

9 (original). The article as set forth in claim 1 and further including a graphics layer adjacent a second surface of said article.

10 (withdrawn). A method for making an article having a luminous surface, said method comprising the steps of:

- depositing a first translucent layer on a release layer;
- depositing a first electrode on the first translucent layer;
- depositing a phosphor layer or a dielectric layer on the first electrode;
- depositing a dielectric layer or a phosphor layer on the preceding layer;
- depositing a second electrode on the preceding layer;
- depositing a protective layer on the second electrode;
- curing the deposited layers;
- placing the release layer and cured layers in a mold with the release layer facing outwardly;

injecting resin into the mold behind the protective layer;
curing the resin;
removing the article from the mold; and
removing the release layer.

11 (withdrawn). The method as set forth in claim 10 wherein at least one of the depositing steps is the step of screen printing.

12 (withdrawn). The method as set forth in claim 10 wherein at least one of the depositing steps is roll coating.

13 (withdrawn). The method as set forth in claim 10 wherein the protective layer is UV curable resin and the curing step includes the step of irradiating the protective layer with UV radiation.

14 (withdrawn). The method as set forth in claim 10 wherein the curing step is performed after each depositing step.

15 (withdrawn). The method as set forth in claim 10 and further including the step of:
placing a graphics layer in said mold, separated from said release layer.

16 (withdrawn). The method as set forth in claim 15 wherein said injecting step includes the step of injecting resin at least between said protective layer and said graphics layer.

17 (currently amended). An instrument cluster having at least one electroluminescent lamp as a first surface in a molded portion of the cluster, said instrument cluster characterized in that the cluster includes: ~~a removable release layer overlying the lamp to support the lamp during~~ lamp is an integral part of the cluster as a result of molding.

18 (original). The instrument cluster as set forth in claim 17 and further including a plurality of electroluminescent lamps, wherein at least some of the lamps include a graphics layer.

19 (currently amended). A cellular telephone having an electroluminescent panel as a first surface of a molded portion of the telephone, said telephone characterized in that the panel includes: ~~a removable release layer overlying the panel to support the panel during~~ is an integral part of the telephone as a result of molding.

20 (withdrawn). A method for making an article having a luminous surface, said method comprising the steps of:

- depositing a first translucent layer on a release layer;
- depositing a first electrode on the first translucent layer;
- depositing a phosphor layer or a dielectric layer on the first electrode;
- depositing a dielectric layer or a phosphor layer on the preceding layer;
- depositing a second electrode on the preceding layer;
- depositing a protective layer on the second electrode;
- curing the deposited layers;
- removing the release layer;
- placing the cured layers in a mold;
- injecting resin into the mold behind the cured layers;
- curing the resin;
- removing the article from the mold.

21 (withdrawn). The method as set forth in claim 20 and further including the step of:

- vacuum forming the cured layers prior to injecting resin into the mold.